Thursday, 2/22/2007 2:57:25 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Estimate Number

: 10811

P.O. Number

This Issue

:N/A

: 2/22/2007

: MA

: 24871

S.O. No. : N)

PURCHASED PARTS

Part Number

Drawing Name

: D2258220 D2258 REV B1 **Drawing Number**

Project Number **Drawing Revision** : N/A

: LABEL

Material **Due Date** : B1 :NIA : 3/5/2007

Qty:

20 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By Comment

: Est: B 04.04.15

Reformat; Clarify Step 2 KJ/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG



PURCHASING



Comment: PURCHASING

Issue P/O: 3/69

Make D2258-220 read 220lb / 100kg as per Dwg D2258

Material: Red letters (1.00" min height) with adhesive back

Manufacture from 3M 7mil masking film #8522CP or Avery IPM #2031

Material release note is required

2.0



1.0000 Each(s)/Unit

Total:

20.0000 Each(s)

Placard

WEIGHT PLACARD 220 LB

3.0

Comment: Qty.:

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage Ensure material release note is attached

4.0

QC6



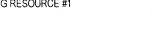
Comment: DIMENSIONAL CHECK



5.0

PACKAGING

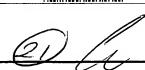
PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				(4)						
			¥							
Part No	•	PAR #· Fault Category:	NCP: Vas	NO DOA		Date: «	aks he			

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
	T	Description of NC	Corrective Action Section B			Varification	Ammunicat		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	

NOTE: Date & initial all entries

Date: User: Thursday, 2/22/2007 2:57:25 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL

Job Number: 30810

Part Number: D2258220

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

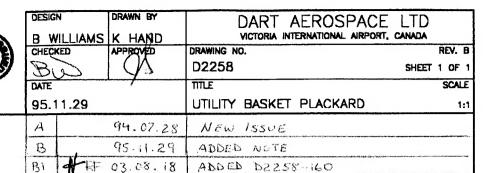


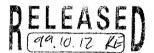
W D7.B:08

Dart Ae	rospace L	.td								
W/O:			W	ORK ORDER CHANG	GES					
DATE STEP		PROCEDURE CHANGE			ŕ	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							9			
Part No:		PAR #:	Fault Cate	egory:	_ NCR	: Yes	No DQA	\:	Date:	
				QA: N/C Closed: Date:						
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC Section A Co Initial Chief Eng		Corrective Action Sec Action Description Chief Eng	ection B n Sign & Date		Verification Section C		Approval Chief Eng	Approval QC Inspector
				Onto Eng						
						-	0			

NOTE: Date & initial all entries







1" RED LETTERS ADHESIVE BACK

MAXIMUM DISTRIBUTED LOAD XXX lb/ XXX kg

EXAMPLE

PART #	LOAD					
D2258-132	132 lb/60 kg					
D2258-200	200 lb/91 kg					
D2258-220	220 lb/100 kg					

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

AVERY GRAPHICS.

PRODUCT DATA BULLETIN

Product Data Bulletin: A5-O

Avery Graphics™ A5 Opaque 5-year INTERMEDIATE calendered vinyl film

Dated: 10/3/02

Description:

Avery GraphicsTM A5 Opaque intermediate films are flexible, high-gloss calendered vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendered vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

Physical Properties:

The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)**
- · Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 6877° F (20° 25° C) and 50±5% R. H.
- Typical Adhesion Values: 180° Peels

 Substrate
 24 hrs
 1 week

 Stainless Steel
 4.4 lbs/in
 5.1 lbs/in

 Glass
 4.7 lbs/in
 5.3 lbs/in

NOTE: Tested per ASTMD 1000. Always pre-test your specific substrate prior to actual application.

Reflectivity: NA

Typical Gloss*: 70 at 60°

Avery Graphics™ A5 Opaque page 1 of 2 AnswerLine: 800-443-9380 Signage.averygraphics.com Avery Graphics™ A5 Opaque page 2 of 2

- Tensile at Yield: 9.0 lbs/in to 15.0 lbs/in width
- Elongation: 100% minimum
- Dimensional Stability: Less than 0.03 in. (0.762mm). Shrinkage is determined by measuring shrinkage of unprinted film applied to to 36 in.2 (91 cm²) aluminum test panel after 72 hrs. aging at 73° F (23° C) 50±5% R.H. followed by 48 hrs. at 150° F (65° C).

Typical Converting Methods:

CUTTING

Computer Sign Cutting: yes Angle of Blade: 30° or 45° Minimum letter Height: 0.5 inch

PRINTING

Thermal Transfer Printing: yes

Ink Jet Printing: no E-Stat printing: no Screen Printing: no

Exceptions:

Durability Exceptions: Colors with reduced durabilities are as follows: A5077-O Silver and A5247-O Gold are 3-year durable and A5003-O Clear is 4-year durable.

Gloss Exceptions: A5077-O Silver, A5247-O Gold and A5508-O Vibrant Blue have a typical gloss of 50 at 60°.

Pigmented Adhesive Exceptions: none

** Some color fade may occur in severe environmental areas such as, Florida, Arizona, Nevada, New Mexico, Utah, Southwest Texas and Southern California. Durability statement does not apply outside of the contiguous 48 states as testing has not been done in those regions.

WARRANTY. All statements, technical information and recommendations about Avery Dannison products are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All Avery Dennison products are sold with the understanding that Purchaser has independently determined the suitability of such products for its purposes. Avery Dennison products are warranty all Avery Dennison products are sold with the understanding that Purchaser has independently determined to be free from defects in material and workmanship for either one year (or the period stated on the specific product information literature in effect at time of delivery, if longer) from date of shipment if said product is properly stored and applied. It is expressly gened and understood that Avery Dennison's sole obligation and Purchaser's exclusive remerly under this warrantly, under of shipment if said product is properly stored and applied. It is expressly gened and understood that Avery Dennison's election, express or implied, or otherwise, shall be limited to repair or replacement of defective product without charge at Avery Dennison's plant or at the location of product (at Avery Dennison's election), or in the event replacement or repairs is not commercially practical, to Avery Dennison's issuing Purchaser a credit reasonable in light of the defect in the product.

Avery Dennison's liability for defective products shall not exceed the purchase price paid therefore by Purchaser and in no event shall Avery Dennison be responsible for any incidental or consequential damages whether foreseeable or not, caused by defects in such product, whether such damage occurs or is discovered before or after replacement or credit, and whether or no such damage is caused by Avery Dennison's negligence.

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Graphics Division North America

Hamilton, OH 45011 AnswerLine: 800-443-9380 www.signage.averygraphics.com

